

FIG. 1

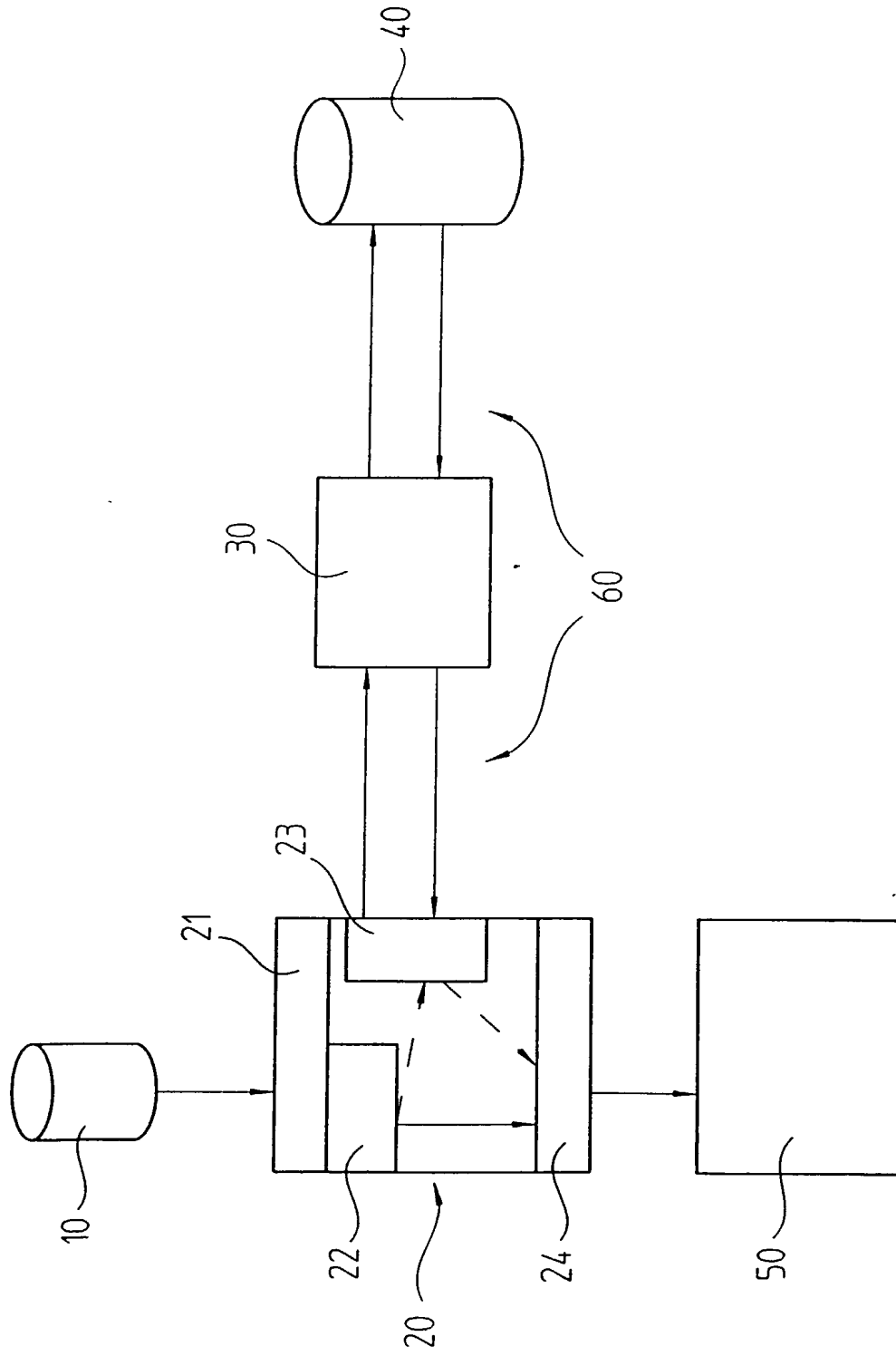


FIG. 2

2/2

10

%123 G71

N110 SQL BIND Q1 = 'TOOL.RADIUS'

N120 SQL BIND Q2 = 'TOOL.LENGTH'

N130 SQL SELECT LENGTH,RADIUS FROM
TOOL WHERE TOOLNUMBER = 2

N140 T2 DR Q1 DL + Q2

N150 G17 S1000 M3

N160 G01 G91 X10 Y100 F200

%123 G71